

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002441**Date Inspected:** 02-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Lin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed visual weld inspection to the deck panels DP-053-001 welds 5 thru 10 and deck panel DP- 461-001 welds 2 thru 10. The QA inspector found weld discontinuities on all the weld identified as incomplete fusion, overlap, under fill, undercut, oversize and undersize welds. Deck Panel DP-053-001 and DP-461-001 had been visual inspected by ZPMC and ABF.

A hand written visual inspection report was generated on this date with all the findings.

The QA inspector observed on OBG assembly shop that ZPMC was performing welding operation at the following locations:

1. Submerged arc welding process (SAW) at the junction of the side panel SP12A and SP20A; welder operator Gao Dong Liang.
2. SAW welding process at the junction of the bottom plates splice BP23A and BP22A for segment 020A, and
3. Flux cored arc welding at the junction of the bottom panel BP-12A to side plate SP30A; segment 016A-008.

The QA inspector observed ZPMC performing ultrasonic testing (UT) on the second time repair at the butt joint on the segment 013 weld joint 007. ZPMC found that the weld appeared to be in accordance with contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

The QA inspector did not have any relevant conversation on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| Inspected By: | Acuna,Alfredo |
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| Quality Assurance Inspector |
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| Reviewed By: | Cuellar,Robert |
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| QA Reviewer |
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